

5/17

DART AEROSPACE LTD	Work Order: 22929
Description: Spacepod Floor	Part Number: D3187-1 D3187-2
Dwg: D3187 Rev. B	Qty: 26 25
Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	HA	05.04.06	25
2	PG	Cut blank: (53.50" x 20.00") Issue PD Material: 6061 T6 (QQ-A 250/11) 0.050" thick (M6061T6S.050) D3187-1 per dwg Batch: GFT	LC	05-04-06	26
3	RA	Cut & drill per template D3187-1T1 & Dwg D3187 Receive & Inspect for transit damage	CL	05/04/09	26
5	GA	Deburr	N/A ml	05-05-04	26
4	QC6	Inspect work up to Step 4	ml	05-05-04	26
6	FP	Acid etch and Alodine as per QSI 005 4.1			
7	FP	Powder Coat Black Sandtex (Ref. 4.3.5.7) per QSI 005 4.3			
8	QC3	Inspect Powder Coat			
9	GA	Cut D2986 Neoprene Foam per template D2986T1 Batch: _____			
10	GA	Attach Neoprene Foam using Contact Cement Note: D3187-1 or D3187-2 side as per Dwg D3187			
11	QC5	Inspect work to Step 10			
12	GA	Go to KP	ml	05-05-04	26 ml
6	Stores	Identify & stock 38.00 545 05/05/05 (26)			

Rev	Date	Change	Revised By	Approved
A	03.04.22	New Issue	KJ/RF	
B	04.08.18	Revised Step Numbering	KJ/JLM	

RELEASED
11/04/08-18

7	DC	Close w/o Inspect level 21	HA	05.05.10	26
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

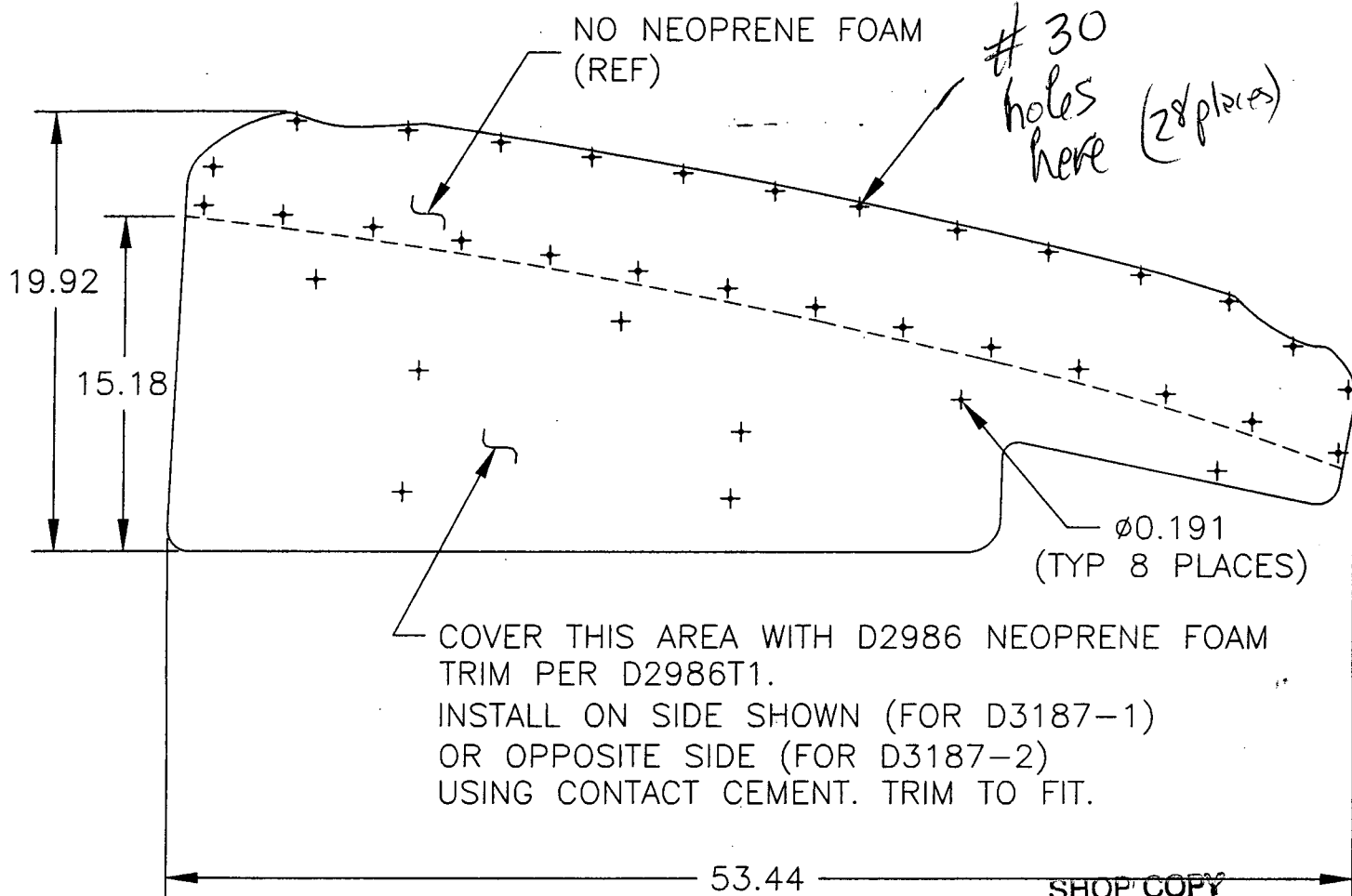
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3187	REV. B SHEET 1 OF 1
DATE 03.05.16		TITLE SPACEPOD FLOOR	SCALE NTS
A	03.03.31	NEW ISSUE	
B	03.05.16	CHANGE SHAPE	

RELEASED
03.06.25



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WITHOUT NOTICE

D3187-1/-2 SPACEPOD FLOOR

- 1) CUT/DRILL ALUMINUM PER TEMPLATE D3187-1T1
- 2) CUT NEOPRENE FOAM PER TEMPLATE D2986T1
- 2) MATERIAL: 6061-T6 (QQ-A-250/11) ALUMINUM SHEET, 0.050 THICK (REF DART SPEC. M6061T6S.050)
- 3) FINISH: BEFORE ATTACHING NEOPRENE, POWDER COAT BLACK SANDTEX (403.57) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

WORK ORDER

22929

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 06, 2005
01:16 pm

Work Order No : 0022929
Project Name : D3187-1
Project For : WK517
Work Order Type : Main
Main WO Number :
House Part Number : D3187-1
Description : Spacepod Floor
Manufactured : Yes
Amount Req'd : 25
Amount Done : 0
Start Date : 04-06-05
Est Finish Date : 04-28-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. 1 OUR JOB NO J0126542 SHIPPING MEMO 0300437

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
<u>--</u>	<u>25 PCS</u>	<u>2007843</u>	<u>D3187-1</u>		<u>SPACEPOD FLOOR</u>	<u>B</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
<u>AL 6061-T6 (QQ-A-250/11)</u>		<u>SAMUEL SPECIALTY</u>		<u>0058695 ATT'D</u>		

	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 26 APRIL 2005

G.F.I. Q.C. REP.

Robert H. [Signature]

Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ --LETTER OF COMPLIANCE

Date: 20 AVRIL 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 0058695

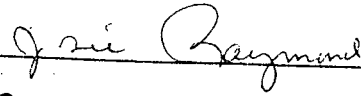
de commande SSMQ: 840290
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

otre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
1	6	.0500" x 48" x 144"	6061 T6		1896401
1	1	.0500" x 48" x 144"	6061 T6		1935201

Bien à vous,
Yours truly,


Commis à l'administration.
Administration Clerk.





CUSTOMER : Samuel Son & Company Ltd
547000
2360 Dixie road
MISSISSAUGA, ONTARIO L4Y 1Z7

YOUR ORDER NUMBER : A14524
OUR ORDER NUMBER : 16237/01
DOCUMENT NUMBER : V/0080064952

Corus Aluminium N.V.
A. Stockellean 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax 32 (0)15 30 27 84

DESCRIPTION : ALU COIL 6061-T6 MF QQA-250/11-AMS 4027 ASTM B209
DIMENSIONS : 48" X 0.05"
ARTICLE NO.:

CAST COIL
NUMBER NUMBER

CHEMICAL COMPOSITION (%)

	SI	FE	CU	MN	MG	CR	TI	ZN
MIN	0,40		0,15		0,8	0,04		
MAX	0,8	0,7	0,40	0,15	1,2	0,35	0,15	0,25
1896401 001	0,67	0,3	0,22	0,08	1,0	0,15	0,01	0,01

OTHERS : EACH : MIN 0,05 MAX
TOTAL : MIN 0,15 MAX

TEST-
NUMBER

MECHANICAL PROPERTIES

1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI
/A = REAR END /M = MIDDLE /V = FRONT END /O = RANDOM SAMPLING

	RM KSI	RP02 KSI	A
MIN	42	35	8
MAX			10
001 /A	49	39	16
001 /M	49	39	14
001 /V	48	39	14

HEAD OF LABORATORY,
XAVIER SCHELTJENS

Corus Aluminium Rolled Products - Corus Aluminium Extrusions